

157005

Wednesday, February 08, 2017 10:19:29 AM

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 2/16/2017 **Start Qty:** 1.00 ***1***

Required Date: 2/27/2017 **Req'd Qty:** 1.00 ***1***

Reference:

FEB 14 2017

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
-----------------	---------------------

D350-607-1

A

DAS
21
9-89

1702-16

100 Document Control

FEB 15 2017

DAS 6 9-89

100

DC

Memo

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPP D350-607-241
CHG001
Paperwork not req'd if packaged with basket

DAS
28
9-89

EFFR 17 2017

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

FEB 16 2017

DAS 6 9-89

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

DAS
28
9-89

FEB 17 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																										
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Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
Misidentified ☐	Past Due ☐																																																																

Work Order ID 157005***157005***

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Wednesday, February 08, 2017 10:19:29 AM

Item ID: D350-607-241

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: AS350/355 Basket Mounting System

Start Date: 2/16/2017 Start Qty: 1.00

1

Cust Item ID:

Required Date: 2/27/2017 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-607-241								
	Location: _____								
	PPP rev: <u>stop</u>								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.02							
Quality Control									

DAS
27
9-89

FEB 17 2017

DAS
21
9-89

FEB 21 2017

unc
17-2-17

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Misidentified ☐	Past Due ☐																																																																

Picklist Print

Wednesday, February 08, 2017 10:19:29 AM

Page 1

Work Order ID: 157005

157005

Parent Item: D350-607-241

D350-607-241

Parent Item Name: AS350/355 Basket Mounting System

Start Date: 2/16/2017

Required Date: 2/27/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: New issue DD verified by:EC
as per ECN10-545 DD 10.04.16 verified by:EC
AS PER IIN REV.A DD VERF:JLM
IPP Rev:B
IPP REV:C 13.08.07

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2230-1		Manufactured	No			110	Each	86.0000	4	4			
D2230-1									**			FEB 16 2017	DAS 27 9-89
Mounting Lug													

Location Loc Qty Loc Code

FG	4	
150062	2	
84136	2	
ST521	32	
115306	1	
<u>151611</u>	31	
ST525A	50	
153924	50	

D2230-3		Manufactured	No			110	Each	242.0000	4	4			
D2230-3									**			FEB 16 2017	DAS 27 9-89
Mounting Lug													

Location Loc Qty Loc Code

FG	6	
109344	4	
89045	2	
ST321	80	
154877	80	
ST521	156	
151426	76	
<u>153925</u>	80	

Picklist Print

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Work Order ID: 157005

157005

Parent Item: D350-607-241

D350-607-241

Parent Item Name: AS350/355 Basket Mounting System

Start Date: 2/16/2017

Required Date: 2/27/2017

Start Qty: 1.00

Required Qty: 1.00

D2732 Manufactured No

110 f

338.6330 2 2

D2732

Rubber Cushion (\$per foot)

**

FEB 16 2017

DAS 6 27 9-89

DAS 28 9-89

Location

Loc Qty

Loc Code

ST412

338.6330494

117118

5E-10

150042

338.633049

2

AN4-15A Purchased No

110 Each

461.0000 8 8

AN4-15A

Bolt

**

FEB 16 2017

DAS 6 27 9-89

DAS 28 9-89

Location

Loc Qty

Loc Code

GA

10

120449

10

over003

240

m135859

240

ST343

211

m135859

211

8

NAS1149D0463J Purchased No

110 Each

2,374.000 16 16

NAS1149D0463.J

Washer

**

FEB 16 2017

DAS 6 27 9-89

DAS 28 9-89

Location

Loc Qty

Loc Code

GA

80

M134508

13

M135056

67

ST263

2294

M136192

15

M136263

279

M136665

2000

10

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

Picklist Print

Page 3

Wednesday, February 08, 2017 10:19:29 AM

Work Order ID: 157005

157005

Parent Item: D350-607-241

D350-607-241

Parent Item Name: AS350/355 Basket Mounting System

Start Date: 2/16/2017

Required Date: 2/27/2017

Start Qty: 1.00

Required Qty: 1.00

MS21042L4

Purchased

No

110

Each

1,666.000

8

8

MS21042L4

Nut

FEB 16 2017
DAS 27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

FP001

18

m133363

18

GA

187

m135058

187

OVER007

500

m136450

500

ST303

961

m136648

961

8

Wednesday, February 08, 2017 10:19:29 AM

Shop Packet Print

Page 3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

6.0 PARTS LIST

6.1 D350-607-041/-041A/-043/-043A HELI-UTILITY-BASKET™

Qty -041	Qty -041A	Qty -043	Qty -043A	Qty -241	Part Number	Description
X					D350-607-041	HELI-UTILITY-BASKET
	X				D350-607-041A	HELI-UTILITY-BASKET
		X			D350-607-043	HELI-UTILITY-BASKET
			X		D350-607-043A	HELI-UTILITY-BASKET
1	1	1	1	X	D350-607-241	BASKET CLAMP KIT INSTALLATION
2	2	5	5		D2022-101	SPACER
1	1	1	1		D2221	BASKET BASE ASSEMBLY
				4	D2230-1	LUG
				4	D2230-3	CLAMP
1	1	1	1		D2258-200	LABEL
1	1	1	1		D2324	STRUT
1		1			D2332-041	PROP ASSEMBLY
1	1				D2512	BASKET LID ASSEMBLY
1	1	1	1		D2530	HANDLE WELDMENT
2	2	2	2		D2535	SPRING
2	2	2	2		D2537	BUSHING
				8	D2732-030	RUBBER CUSHION
2	2	2	2		D2931	BUMPER
		1	1		D2989-041	BASKET LID ASSEMBLY (OUTSIDE)
		1	1		D2989-043	BASKET LID ASSEMBLY (INSIDE)
	1				D350-607-141	AUTOMATIC LID OPENER INSTL
			1		D350-607-143	AUTOMATIC LID OPENER INSTL
2	2	2	2		AN3-16A	BOLT
2	2				AN4-7A	BOLT
5	5	5	5		AN4-12A	BOLT
		2	2		AN4-13A	BOLT
				8	AN4-15A	BOLT
1		7	5		AN4-22A	BOLT
1					AN4-24A	BOLT
4	4	4	4		AN5-17A	BOLT
2	2	2	2		MS20600AD4W3	RIVET (OR CR9163-4-3)
12	12	24	24	16	NAS1149D0463J	WASHER (OR AN960JD416)
2		2			NAS1149D0416J	WASHER (OR AN960JD416L)
4	4	4	4		NAS1149D0563J	WASHER (OR AN960JD516)
2	2	2	2		NAS1149DN832J	WASHER (AN960JD8)
		2	2		NAS1515H4	WASHER
4		4			AN970-4	WASHER
2	2	2	2		MS21042L3	NUT (OR MS21042-3)
9	7	14	12	8	MS21042L4	NUT (OR MS21042-4)
4	4	4	4		MS21042L5	NUT (OR MS21042-5)